

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020143**Date Inspected:** 23-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Yu Jiao (ABF)**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** BAY 14 OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Robert A.DeArmond was present during the time noted above and conducted observations relative to the work being performed.

OBG BAY 14

Ultrasonic Testing (UT)

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a UT report for this date. All components were as listed on NWIT notification no. 07902. The member(s) is/are identified as SEG3019M, (Lift 14 East Line). The weld designations reviewed are as follows:

SEG3019M-027, 032

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OBG BAY 14

This QA Inspector observed the following work in progress:

SMAW welding of complete joint penetration weld joint(s) located on Grillage Plate Sub-Assembly, Segment 13A "W" Line identified as SA7512 weld number(s) 021, 022, and 023. Welder is identified as welder no. 062708. The welding variables recorded by ZPMC QC identified as Li Ping appeared to comply with applicable WPS(s) WPS-B-P-2211-TC-U4b-FCM 1.

SMAW welding of complete joint penetration weld joint(s) located on Grillage Plate Sub-Assembly, Segment 13A "W" Line identified as SA7512 weld number(s) 024, 025, 026, and 027. Welder is identified as welder no. 045203. The welding variables recorded by ZPMC QC identified as Li Ping appeared to comply with applicable WPS(s) WPS-B-P-2211-TC-U4b-FCM 1.

FCAW welding of complete joint penetration weld joint(s) located on Grillage Plate Sub-Assembly, Segment 13A "E" Line identified as SA7038 weld number(s) 225 and 026. Welder is identified as welder no. 067079. The welding variables recorded by ZPMC QC identified as Zhong Yang Gang appeared to comply with applicable WPS(s) WPS-B-T-2231-ESAB.

During random in process inspection of Orthotropic Box Girder; (OBG) member identified as SEG3020* weld number(s) 004. This QA Inspector observed weld repair of complete joint penetration weld joint(s). ZPMC Quality Control personnel previously tested and rejected portions of this weld.

SMAW welding of complete joint penetration weld joint(s) located on DP3170 to DP3171 identified as noted above. Welder is identified as welder no. 045246. The welding variables recorded by ZPMC QC identified as Li Ping appeared to comply with applicable WPS(s) WPS-345-SMAW-1G-(1F)-Repair-FCM

During random in process inspection of Orthotropic Box Girder; (OBG) member identified as SEG3020* weld number(s) 003. This QA Inspector observed weld repair of complete joint penetration weld joint(s). ZPMC Quality Control personnel previously tested and rejected portions of this weld.

SMAW welding of complete joint penetration weld joint(s) located on DP3169 to DP3170 identified as noted above. Welder is identified as welder no. 045246. The welding variables recorded by ZPMC QC identified as Li Ping appeared to comply with applicable WPS(s) WPS-345-SMAW-1G-(1F)-Repair-FCM

During random in process inspection of Orthotropic Box Girder; (OBG) member identified as SEG3020* weld number(s) 006. This QA Inspector observed weld repair of complete joint penetration weld joint(s). ZPMC Quality Control personnel previously tested and rejected portions of this weld.

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SMAW welding of complete joint penetration weld joint(s) located on DP3173 to DP3172 identified as noted above. Welder is identified as welder no. 045246. The welding variables recorded by ZPMC QC identified as Li Ping appeared to comply with applicable WPS(s) WPS-345-SMAW-1G-(1F)-Repair-FCM

Please see attached photo

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

As mentioned above between QA and QC concerning this project

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 1500-0042-02372, who represents the Office of Structural Materials for your project.

Inspected By:	DeArmond,Robert	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
